

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003118**Date Inspected:** 12-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sai Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

Bay 3--New Tower Building

The QA Inspector randomly observed ZPMC welding and QC personnel performing inspection, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-seven (37ea) deck panels are inside the shop. The deck panels in repair process are designated as: DP052-001, DP055-001, DP078-001, DP067-001, DP006-001, DP051-001 & DP065-001. The QA Inspector spent a portion of the shift monitoring and documenting the repaired locations on DP027-001. The work in progress appeared to be in general compliance with the contract specifications.

Visual Testing (VT)

The QA Inspector performed initial VT, along with ABF and ZPMC QC personnel on deck panel DP065-001 prior to the initiation of welding repairs. Once the inspection was completed and a mutual agreement was reached for each marked area, a representative for each party signed and dated the yellow in process repair tracking sticker. Repair work for this deck panel was initiated as of 1630hrs.

During and initial observation the QA Inspector observed ZPMC personnel performing grinding for FCAW weld repairs located on the weld termination areas of DP052-001 and DP055-001. The QA Inspector was informed by

WELDING INSPECTION REPORT

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ABF QC Warren Buehler that once ZPMC completes these repairs, ZPMC will re-verify the areas by MT inspection before the yellow repair tracking tag would be signed off by ABF and Caltrans. Later in the shift the QA Inspector observed that ZPMC MT verification was still pending at the end of second shift.

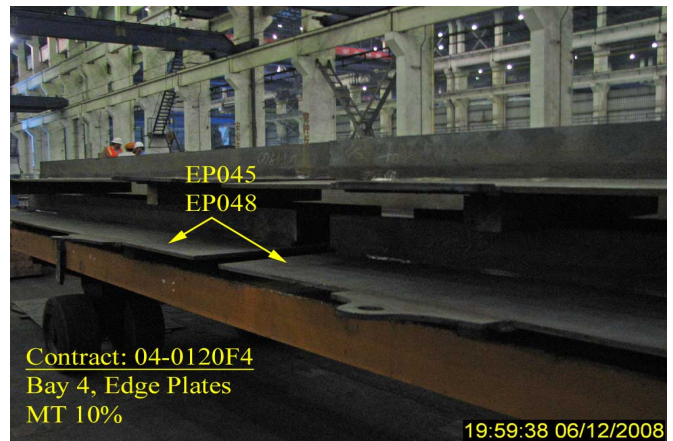
OBG-Bay 4

The QA Inspector performed MT verification after ZPMC QC acceptance for approximately 10% of the weld lengths for two edge beam plates designated as EP045 & EP048. The QA Inspector observed no apparent relevant indications upon completion of testing and generated a TL-6028 MT report on this date.



SFOBB QA VERIFICATION TAG				
IN-PROCESS				
SUBASSEMBLY DP065-001				Tag No. 0000000011
INSPECTIONS			REPAIRS	
	ZPMC	ABF	CT	
FVT				CWR
UT				HSR
MT				NCR
RT				
Dimen.				
Notes: Initial VT 06/12/08 - Subscale 26.12 32.877 6/12/08				

16:36:02 06/12/2008



Summary of Conversations:

As noted above in report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Leach,Ed

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer